

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008596**Date Inspected:** 24-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** CWI: Zhan Bo**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower components**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector, Dilip Chakrabarti was present during the times noted above for observations relative to the work being performed.

Bay# 10- Tower Assembly:

This QA Inspector randomly observed the following work in progress:

Bay# 14- OBG Assembly:

This QA Inspector randomly observed the following work in progress:

Ultrasonic Testing (UT):

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-6027 UT report on this date.

The member and the weld designations are as follows:

Sl # Section # Weld # Green Tag # Location

1. SEG 056A 005 NA NA

2. SEG 056A 011 NA NA

3. SEG 056A 020 NA NA

SAW Process:

Welding of weld Joint# 33 located on PCMK SEG 052*. Welder is identified as 044771. ZPMC QC is identified as Zhong Guo Hui. The welding variables recorded by QC appeared to comply with the specified WPS no.

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B-T-223(2)1.

Welding of weld Joint# 34 located on PCMK SEG 052*. Welder is identified as 048038. ZPMC QC is identified as Zhong Guo Hui. The welding variables recorded by QC appeared to comply with the specified WPS no.

B-T-223(2)1

Bay# 11- Tower Assembly:

This QA Inspector randomly observed the following work in progress:

FCAW Process:

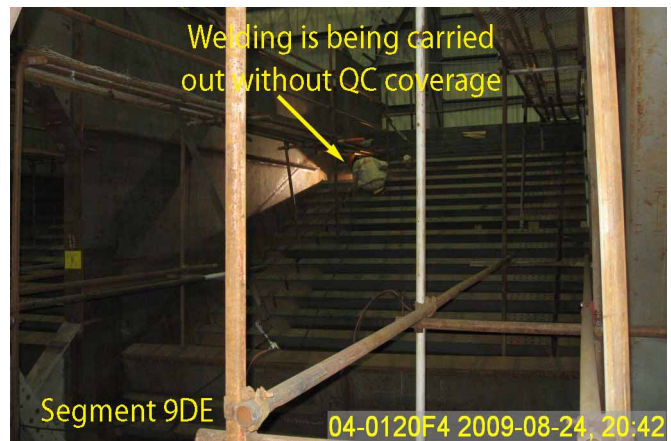
Welding of weld Joint# 3 located on PCMK WSD1 FESA4-4 B/F. Welder is identified as 066882. ZPMC QC is identified as Zhan Bo. The welding variables recorded by QC appeared to comply with the specified WPS no.

B-T-4332-TC-P4-F.

Unless otherwise noted, all work observed on this date appeared to be generally comply with applicable contract documents.

Summary of Conversations:

This Quality Assurance inspector (QA) observed the contractors welding personnel perform welding joint# identified as SP 627-001 on OBG segment 9DE in Bay# 14. The contractors Quality Control inspector (QC) was not present to monitor the weld parameters for more than 45 minutes. The QC inspector was busy in other area. No CWI was also available in the shop during this period. This QA Inspector has issued an incident report.



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Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By:	Chakrabarti,Dilip Kumar	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
